

Work Order ID 51111

August 4, 2009 11:04:20 AM

Page 1

Item ID: D350-591-312

Accept

Revision ID: B

Item Name: Heli-Access-Step, Long RH

Setup Start

Stop

Start Date: 8/07/09 Start Qty: 10.00

Required Date: 8/28/09 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *CMF*

Date: *09-08-04*

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

509/05/10

HJ for BG 09/09/08

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod

3-Grind End Plate flush

m111311
m111494

09-08-26

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00	PD 09-08-26						
130  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	=> S09/08/26						(10 RHT) /
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	SAD 09-08-26						(10)

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Reference:

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

150 QC3- Inspect Part Finish

0.00



QC Memo

0.00

Quality Control

PH 09.08.21

10

160 Large Fab

0.00



Large Fab Memo

0.00

Large Fab

Assemble Leg Assembly as per Dwg D3272.

PH 09.08.21

10

170 QC5- Inspect part completeness to step on W/O

0.00



QC Memo

0.00

Quality Control

=> 8/08/09/27

(100%)

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Required Date: 8/28/09 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

0.00



Large Fab

Large Fab

Memo

0.00

10

1-Bevel Aft end for welding

sh

2-Inspect for foreign object as per QSI 024

sh

3-Weld Aft End Plate as per QSI 004 & DwgD3272

sh

A/RAluminum Rod

M111311

sh

4-Grind End Plate flush

sh

5-Install last rivet.

sh

sh 09.08.27

190

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

PD 09.08.28

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

210

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 11:00am

OVEN TEMPERATURE: 320°F

FINISH TIME: 11:30am



=> 502/08/28

10RH

=> 9/09/08/28

10RH

=> 9/11/08/31

10RH

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Required Date: 8/28/09 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230



HandFinish

Wing Walk as per dwg QS1005 4.4 Batch

Memo

0.00

0.00

Hand Finishing

240



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

250



Packaging

Packaging

Pick Kit

Memo

0.00

0.00

BR 09-09-2 (10)

Pc 9/5/9 (10)

Pc 9/5/9 (10)

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-312
Location: *Rw*

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

9/9/11 (10x) SP

09/09/14 *[Signature]*
MF 09-09-11

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Picklist Print

August 4, 2009 11:04:19 AM

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Work Order ID: 51111

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH



Comments:



Start Date: 8/07/09

Required Date: 8/28/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3067-1RevA		Manufactured	No			110	Each	18.0000	10.0000			
											12.08.25	
End Plate												

D3272-1RevB		Manufactured	No			110	Each	0.0000	10.0000			
											10	
Step												
MS21042L5		Purchased	No			110	Each	1,615.000	20.0000			

S
40 Nut

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

351104

48242

18

18

12.09.08.25

10

351123

12.09.08.25

10 12.09.08.25

250
=> change lat's code

12.9.9 (10)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

1615

110382

10

111127

105

111636

500

112314

1000

1111636

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Heli-Access-Step, Long RH

Comments:

Start Date: 8/07/09

Required Date: 8/28/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3065-041RevB		Manufactured	No			160	Each	24.0000	10.0000			
Step Leg Assembly Hi												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST 350095	24	1209.08.27 10
48113	24	

D3066-1RevB		Manufactured	No			160	Each	37.0000	20.0000			
Spacer												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST 351121	37	1209.08.27 14
48414 350383	37	6

D3219-1RevA		Manufactured	No			160	Each	77.0000	20.0000			
Plate												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST 47296	77	1209.08.25 20
	77	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 8/07/09

Required Date: 8/28/09

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20600-AD4W4		Purchased	No			180	Each	3,335.000	160.0000			
												
Rivets												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	3335	
110731	215	
111359	46	
111477	74	
112082	1000	
112314	2000	

Handwritten: 09.08.27 160

AN3-35A 24

Purchased

No

260

Each

605.0000

20.0000



Bolt

Handwritten: 09/15/10 (10)

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	605	
106993	12	
110467	93	
112314	500	

Handwritten: 110767

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-13A 8P Bolt		Purchased	No			260	Each	1,243.000	80.0000			

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

1243

107321

1

107534

5

107959

23

109285

37

110552

66

110865

3

111477

9

111925

99

112314

1000

17406

0

AN5-36A 2P

Purchased

No

260

Each

601.0000

20.0000

Bolt

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

601

109545

11

110467

7

110731

4

112243

79

112314

500

W/O:		WORK ORDER CHANGES					
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Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10	4x	Purchased	No			260	Each	1,827.000	40.0000	✓		



Washer

8/9/10 (10)

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

1827

105442

95

109059

2

109840

23

110985

202

111279

13

111668

492

112314

1000

OK
OK
OK
OK
OK
OK
OK

1112369

105792

8x

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AN960JD416 10X Washer		Purchased	No			260	Each	11,708.00	160.0000	✓		

8/9/10 (10)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

11708

102929

20

105906

40

107321

230

107939

1140

108161

553

108827

310

109249

690

110523

3400

111279

5720

111916

5000

112314

5000 ok

16941

0

1109248 36X

1111916 124X

W/O:		WORK ORDER CHANGES					
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---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960JD516 yx

Purchased

No

260

Each

1,753.000

40.0000

✓



S

Washer

8/9/09 (10)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1753

100564

2

106167

6

107534

34

107959

43

108246

46

108672

2

109059

49

109752

22

110363

46

110523

57

111279

44

112082

902

112314

500

⊗

8/12/09

D2230-3RevF yx

Manufactured

No

260

Each

49.0000

40.0000

✓



S

Lug

8/9/09 (10)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

49

22121

0

48384

49

B31187

August 4, 2009 11:04:19 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Qty: 10.00

Required Qty: 10.00


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2618RevB1		Manufactured	No			260	Each	60.0000	20.0000			
												
Bushing												

PC 9/9/09 (10)

Warehouse	Loc Qty	Loc Code
Location		

Main Warehouse		
ST039	60	
50659	60	

D2856-400RevA		Manufactured	No			260	f	157.4477	6.0000			
												
Abraison Strip												


50659

PC 9/9/09 (10)

Warehouse	Loc Qty	Loc Code
Location		

Main Warehouse		
ST	157.4477	
42437	44.93	
46543	112.5177	

350793

D3067-1RevA		Manufactured	No			200	Each	18.0000	10.0000			
												
End Plate												

*200
110
change routing code*

PC 09-09-10

Warehouse	Loc Qty	Loc Code
Location		

Main Warehouse		
ST	18	
48242	18	

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 4, 2009 11:04:19 AM

Page 9

Work Order ID: 51111

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Comments:

Start Date: 8/07/09

Required Date: 8/28/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

S
40 D3235-1RevA



Manufactured

No

260

Each

229.0000

20.0000 ✓

Mounting Lug



Per 9/9/9 (10)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

229

45398

4

46745

125

47969

100

46745

S
40 D3278-041RevC



Manufactured

No

260

Each

40.0000

10.0000 ✓

Support Assembly



Per 9/9/9 (10)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

40

47886

40

47886

August 4, 2009 11:04:19 AM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 10

August 4, 2009 11:04:19 AM

Work Order ID: 51111

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Comments:

Start Date: 8/07/09

Required Date: 8/28/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21042L3 <i>2p</i>		Purchased	No			260	Each	3,517.000	20.0000	✓		
---------------------	--	-----------	----	--	--	-----	------	-----------	---------	---	--	--



Nut

Pg 5/5 (10)

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

3517

110844

32 *Q*

111274

493

111668

992

112314

2000

M/12274

MS21042L4 *8p*

Purchased

No

260

Each

10,192.00 80.0000

✓



Nut

Pg 5/9 (10)

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

10192 *Q*

107499

5 *Q*

110507

2146 *Q*

111827

6000

112314

2000

15924

0 *Q*

8182

41 *Q*

M/10507 70x
M/12314 10x

August 4, 2009 11:04:19 AM

Shop Packet Print

Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. F SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *th*

*#5111
mf
09-06-04*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

△
B

GENERAL NOTES:

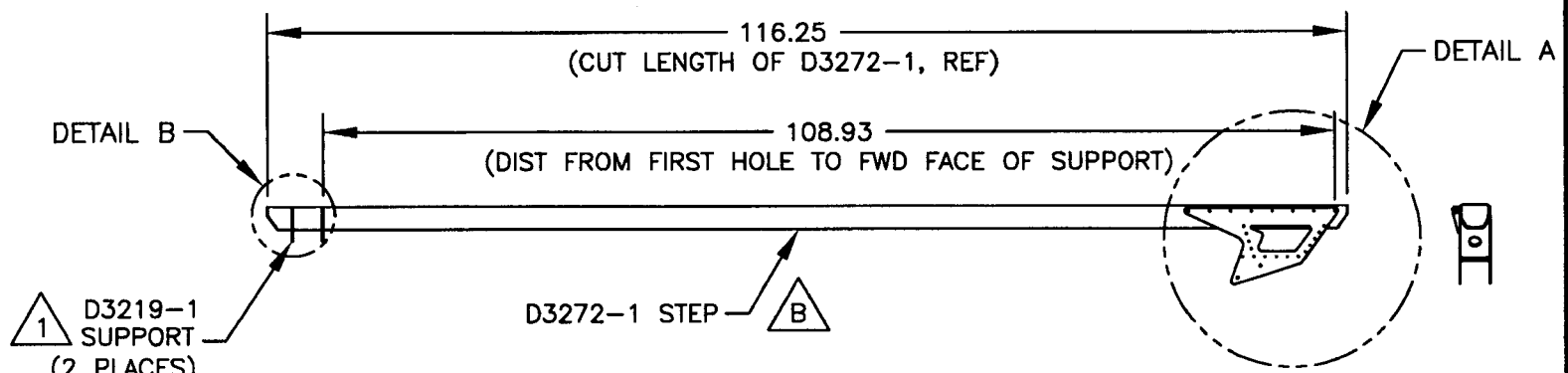
- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

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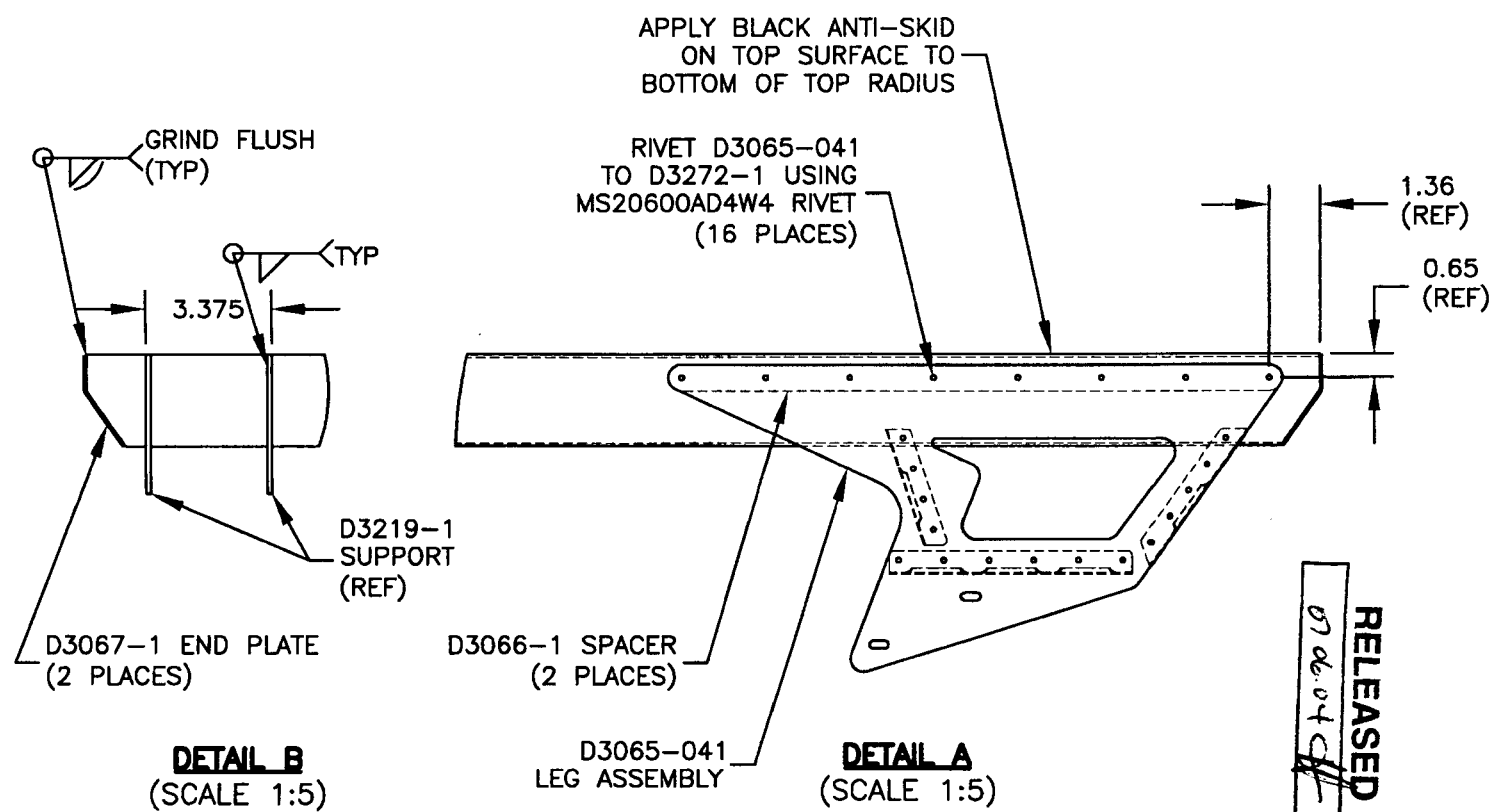
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DESIGN 90	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3272	SHEET 2 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20	



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



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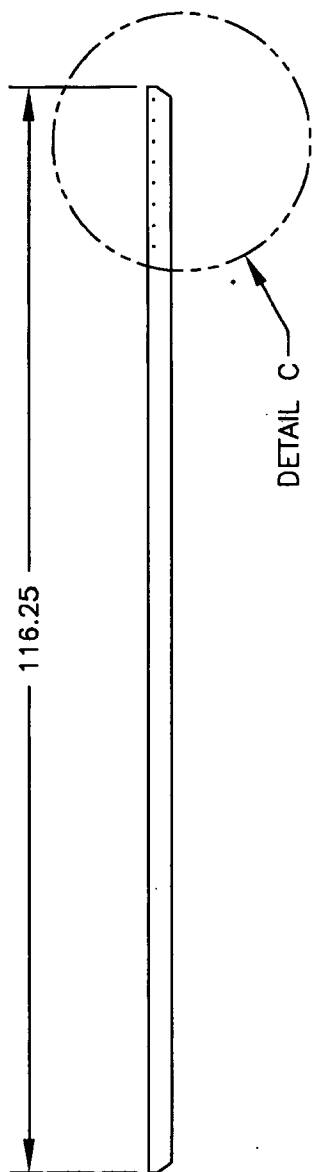
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DESIGN <i>qp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. <i>1</i> SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

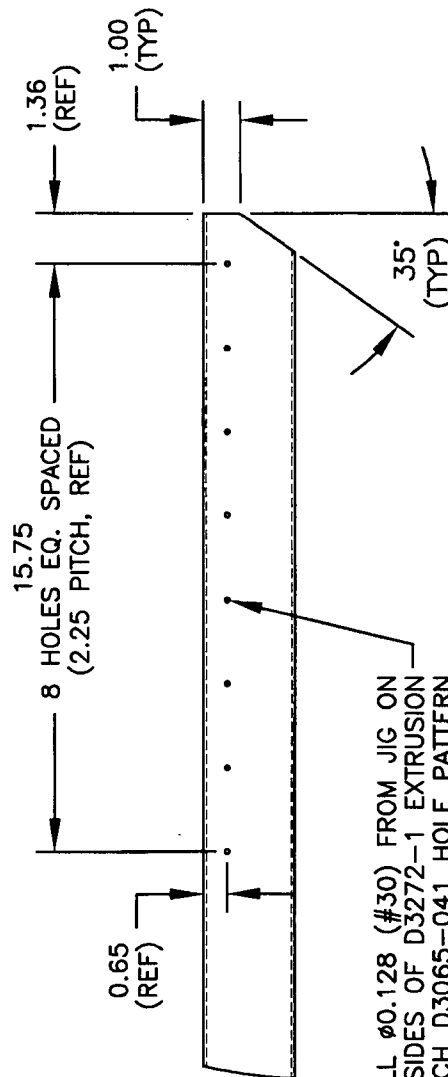
RELEASED

07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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D350-591
Page 23 of 23

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step™</i> , Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step™</i> , Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step™</i> , Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step™</i> , Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step™</i> , Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step™</i> , Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step™</i> , Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step™</i> , Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.